February 10, 2010 2:56:14 PM



Page 1

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

2/10/10

QC:

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process

Required Date: 2/26/10

Process Plan:

Date: 10-2-10

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours Draw Number Draw Rev. Plan Code Accept Qty

Reject Reject Qty Number

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D2580

Rev D



DOCUMENT CONTROL

I (MINISTERIA) DC

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A HY

110

100

CNC Bend 1

CNC Delta 100 Bender

end 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

M1012/16

Dart Aerospa	ice Ltd	
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W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PR	OCEDURE CHA	NGE	Date Qty	Oate Qty Approval Chief Eng / Prod Mgr						
			, , , , , , , , , , , , , , , , , , , ,									
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes 1	No DQA:	Date: _					
	Resolution: Disposition:											
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCR)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	ion B Sign &	Verification		Approval				
 		oodion.	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector				
								-				
						:						
						:						

Item ID:

D205-634-041

Accept

Setup Start

Stop



Revision ID:

Replacement Skidtube Item Name:

Required Date: 2/26/10

Start Date:

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

QC5- Inspect part completeness to step on W/O

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan Code Stop

Reject

Qty

Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

120

Skidtubes

Skidtubes

Memo

0.00

0.00

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

Memo

Quality Control

0.00

Accept

Qty

W/O:			WC	ORK ORDER CHANG	GES	·					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval* Chief Eng / Prod Mgr	Approval QC Inspector	
									,		
Part No		PAR #:									
	Re	esolution:	Disposition: QA: N/C Closed:						sed: Date:		
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE	(NCR))				
DATE	STEP	Description of NC						Verification A		Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Approval Chief Eng	QC Inspector	
										-	
				·							
				•		·					
	,										

Page 3

February 10, 2010 2:56:14 PM

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

OC:

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: ____ Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/ **Work Center ID**

140

Skidtubes

Skidtubes

Operation **Description** Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Code

Accept **Qty**

Reject Qty

Reject Number Stamp

Insp.

Memo

1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/RCDD Aluminum Rod

m113207

BE 10/02/17

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/RILL Aluminum Rod 113207

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

10-2-23

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval \ Chief Eng / Prod Mgr DATE **Approval STEP PROCEDURE CHANGE** Ву **Date** Qty QC Inspector

Part No: D205-634-041 PAR #: ____ Fault Category: Skickbes NCR: Yes No DQA: Date: 10.55-76

Resolution: ____ Yes work QA: N/C Closed: ____ Date: 10/03/16

NCR: 🥄	0135	Wo	ORK OR	DER NON-CONFORMANCI	E (NCR)			
DATE	CTED	Description of NC		Corrective Action Section B		Verification	Ammroyal	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
welz3	ts 140.6	tube moves on table while dalling Aft cap hole. Causing hole to be classical K.C. Bro Luck first thin this		~ COS Y AIR WILLDON	BE 402/23		1	
		K.C. Box Luck first thin this	POSIUM	- GRIAIS weld Flash enside +	B (1/02/23	8	Islan	wlod23
			Sosiur	- Redrill hale in correct/ocaty.	86, 1902/23	Siolaley	Justour	Sulvelez

Work Order ID 56135

Page 4

February 10, 2010 2:56:14 PM

Required Date: 2/26/10

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

2/10/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Date: ______

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

150

Operation Description

OC10- Inspect visual per QSI004- ground welds

Set Up/

Run Hours

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Quality Control

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Memo

170

HandFinish Hand Finishing Pressure Wash per QSI005 4.3

Memo

PAR 09-04300 Bl 10-3-1

Dart Aerospace	Ltd	
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W/O:			W	ORK ORDER CHANG	ES		,		
DATE	STEP	PROCEDURE CHANGE By					Qty	Approvat Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:	1	Date:	
Resolution: Disposition:				_ QA: N/C Cld	osed:		Date:		
NCR:			WORK ORD	DER NON-CONFORMA	ANCE (NCR)		,,	
DATE	STEP	Description of NC	Corrective Action Solution Initial Action Description		ion B	Verification		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	ı C	Chief Eng	QC Inspector
		:							

Work Order ID 56135

February 10, 2010 2:56:14 PM



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Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Date:

2:30pm

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Date:

Draw Plan

Code

Date:

Start Run

Reject

Qty

Stop



Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: OVEN TEMPERATURE:

FINISH TIME:

Set Up/ **Run Hours**

Number Rev.

Draw

11 10/03/01

Qty

Accept

190

Quality Control

QC3- Inspect Part Finish

Memo

0.00

L 10-03-3

Dart Aerospace	Ltd
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W/O:	1		\M/	ORK ORDER CHANGE	<u> </u>								
	STEP	PRO	PROCEDURE CHANGE				Qty	Approval · Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:	Fault Cate	Fault Category:			NCR: Yes No DQA: Date:						
	Re	esolution:	Dispositio	on:	QA: N/C CI	osed:		Date:					
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	()							
DATE	STEP	Description of NC	Initial		Section B on Sign &		cation	Approval	Approval				
		Section A	Chief Eng	Action Description Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector				
		·							-				
								:					
	1		1 1		ı	,							

3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R 🗆 🗆 Sikaflex-291

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1132/62

W/O:		7,37	WC	RK ORDER CHANG	GES							
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approvat ^a Chief Eng / Prod Mgr	Approval QC Inspector			
<u>,</u> .			-									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
	Resolution: Disposition:											
NCR:		,	WORK ORDE	ER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC			ction B	Verification		Approval	Approval			
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector			
	1 1		1 1		ł	ì			1			

Work Order ID 56135

February 10, 2010 2:56:14 PM



Page 7

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

Start Oty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: _____ Date:

Run

Start

Stop



Sequence ID/

Work Center ID

210

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/

SPC (Y/N):

0.00

0.00

0.00

Run Hours

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

230

QC

Packaging

Packaging

Packaging

Memo

Memo

Identify and pack for shipping as per PPPD205-634-041

OC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/03/059f MF 10-3-05

Quality Control

W/O:			WO	RK ORDER CHANG	GES	,,	7.449		
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:					Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	(1)			
DATE	STEP	Description of NC	Corrective Action Initial Action Description				cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector
									: :
		•							

Replacement Skidtube IPP Rev:NE 02.08.28E IPP Rev. O 06.02.28 IPP Rev:P 07-07-09
Replacement Skidtube IPP Rev:NE:02.08.28E
Replacement Skidtube
205-634-041
6135
2:56:18 PM
t



Page 1

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

PP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2580-1	-	Manufactured	No			110	Each	5.0000	1.0000			

205 Skidtube bent detail

<u>Warehouse</u>	Loc	Oty	Loc Code		
Location					
Main Warehouse	12	56123			M 10/2/16
LG	15	5			
54541		2			
54697		2			
54721		1			
	140	Each	141.0000	1.0000	

D2576-3

| Harm | Harm

Manufactured No

so loc Oty Loc

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	141	
46661	94	
52215	47	

W/O:			W	ORK ORDER CHANGI	ES				
DATE STEP		PR	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #:							
	Resolution: Disposition:			QA: N/C Closed: Date:					
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCF	?)			
DATE	STEP	Description of NC			Section B Veri			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti	on C	Chief Eng	QC Inspector
									-

February 10, 2010 2:56:18 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Replacement Mfg/

Manufactured

Bin Primary No

Last

JLM

Route 140

Unit of Each

Qty on

Remaining 147.0000 20.0000

Start Date: 2/10/10

Start Qty: 1.00

Qty

Status

Required Date: 2/26/10

Required Qty: 1.00

Date

Component Item ID/

Crossbolt S	Spacer
-------------	--------

D2579

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse		<i>y</i>	
LG	25		
51525	4		
53780	3		
54543	18		
Main Warehouse			
ST	122		
43988	4		
46434	4		
46956	2		
47797	9		
48272	2		
51314	71		
51315	30		

B 56145



BE 10/02/17

W/O:			M	ORK ORDER CHANG	GES					
DATE STEP		PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo DQA		Date:	
			Disposition:							
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC		tion B Verifica			ition	tion Approval	Approval	
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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		•								
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Picklist Print

Page 3

February 10, 2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Purchased

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Qty

Required Qty: 1.00

Component Item ID/ D2855

Replacement Mfg/ Manufactured

Primary Bin No

No

Last

Route 200

Unit of Each

Remaining Qty on 151.0000 1.0000

Date

Status

Cap

Warehouse	Lo	c Oty	Loc Code	
Location				
Main Warehouse				
ST026		151		
50513		1		
50770		1		
51539		39		
53791		110		
•	200	Each	1,773.000	2.000

Bolt

AN3-5A

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1773	
100188 105057	188	
105057	1585	

2 bl 10-03-3.

- 1 / 1003-3

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval ² Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	esolution:						Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	ion B Sign & Date	Verific Section	ation on C	Approval Chief Eng	Approval QC Inspector
									-

February 10, 2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Comments:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN960JD10L

Replacement Mfg/ Purchased

Primary Bin No

Last

Route 200

Unit of Each

Qty on Remaining 3,459.000 2.0000

Qty

Date

Status

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3459	
101291	16	
105793 110985	49	
110985	3394	

ALS7-1032-130

Purchased

No

Warehouse Location 200

Loc Oty

Each

986.0000 50.0000

Loc Code

Insert

,		a (
4-	10	OX	- 1	130	

Main W	arehouse		
ST	110511.	986	
	108606	52	
	111529	130	
	111779	34	
	112772	11	
	113238	759	

50 Bl 10-03-3.

DR 16-03-3

			1110							
W/O:			WC	RK ORDER CHANG	BES					
DATE	STEP	PROCEDURE CHANGE				Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cated	orv:	NCR:	Yes N	lo DQ /	<u> </u> 	Date:	
			Disposition: C							
NCR:		T		R NON-CONFORM						<u>-</u>
		Description of NC		Corrective Action Section B			Verification		Approval	Approval
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
	A A									
	1									

February 10: 2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Start Oty: 1.00

Required Date: 2/26/10

Required Qty: 1.00

Component Item ID/ AN3C4A

Replacement Mfg/ Purchased

Bin Primary No

Last

Route 200

Unit of Each

1,263.000 50.0000

Oty on Remaining

Qty

Date

Status

BOLT

Warehouse Location	<u>Lo</u>	oc Oty	Loc Code	
Main Warehouse				
ST		1263		
112314		13		
112720		12		
112724		3		
112829		1		
112991		2		
113121		64		
113226		344		
113422		124		
113644		500		
113749 🗸		200		
	200	Each	388.0000	50.0000

50 Bf 10-03-3.

AN960C10L

Purchased

No

washer

NASINGC 0332R.

Warehouse	Loc Oty	Loc Code
Location		
OFFSHORE 120		
FG 113737	100	
103585	100	
Main Warehouse		
ST	288	
112116	128	
112612	160	

50 . Bl/0-03.3

W/O:			WC	RK ORDER CHANG	ES			·	
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						. ,			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Res	solution:	olution: Disposition:			QA: N/C Closed: Date			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC Corrective Action			Section B Veri			fication Approval App	
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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February 10,, 2010 2:56:19 PM

Work Order ID: 56135

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Manufactured

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3566-13

Replacement Mfg/

Bin Primary Manufactured No

Last

Route 200

Unit of Each

Qty on Remaining 1.0000 83.0000

Qty

Date

Status

Gasket

Warehouse	Loc	<u>Oty</u>	Loc Code		
Location					
Main Warehouse					2
FP /		81			1/1/10-03-3
53461		81			
Main Warehouse	k				
ST ·		2			
45717 .		1			
50265		l			
	200	Each	34.0000	1.0000	



Gasket

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
FP19	30		11
55026 f.	18		1 / 10-03-3
₅₅₃₃₅ V	12		
Main Warehouse			
ST	4		
36113	1		
46186	1		··
47318	1		
51260	1		

W/O:		WORK ORDER CHANGES					-		
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	jory:	NCR: Yes	No DQ	A :	Date:	<u> </u>
			Disposition: Q						
NCR:				R NON-CONFORM			140		
DATE	STEP	Description of NC Corrective Action			ction B	Verific	Verification		Approval
DAIL	JILF	Section A	Initial Chief Eng			Sign & Section C		Approval Chief Eng	QC Inspector
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Picklist Print

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Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

2 Bl 10-03-3

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3566-1

Replacement Mfg/

Bin No Manufactured

Primary Last

Route 200

Unit of Each

Qty on 39.0000

Remaining 2.0000

Qty

Date

Status

Gasket

Warehouse	<u>Lo</u>	c Qty	Loc Code	
Location				
Main Warehouse				
FP		34		
52512 .		3		
54480		1		
55011		3		
55320		27		
Main Warehouse				
ST		5		
46349		1		
51218		1		
51259		3		
	200	Each	5.0000	1.0000

D3564-11

Wearshoe

No Manufactured

Loc Qty Loc Code Warehouse Location Main Warehouse 3 52125 Main

n Warehouse	
ST	
45823	

50112

BR 10-03-3.

Dart	Aer	osp	ace	Ltd
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W/O:			WC	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
F · ·		esolution:						
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	1)		
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section		Verification	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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		·						

Picklist Print

Page 8

February 10,-2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

Manufactured

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Start Date: 2/10/10

Required Date: 2/26/10

Start Oty: 1.00

Required Qty: 1.00

Date

Component Item ID/ D3564-13

Replacement Mfg/

No Manufactured

Primary

JLM

Last

Route 200

Unit of Each

Qty on 23.0000

Loc Code

Remaining 1.0000

Status

Wearshoe

Loc Qty Warehouse Location Main Warehouse 11 FP17 11 51611 Main Warehouse ST

45409 46495

> 44659 45825

12 2

10 Each 1 \$ 10-033

Qty

14.0000 1.0000

D3564-9

Wearshoe

Loc Qty Loc Code Warehouse Location Main Warehouse FP19 12 55025 12 Main Warehouse ST 2

200

bl 10-03-3.

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval - Chief Eng / Prod Mgr	Approval QC Inspector
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Dort No.	<u> </u>								<u></u>
Part No		PAR #:							
	H.	esolution:						Date:	
NCR:			WORK ORL	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
									-

Picklist Print

Page 9

February 10, 2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3564-5

Replacement Mfg/ Manufactured

Bin Primary No

Last

45824 47433 Route 200

Unit of Each

Qty on 44.0000

Remaining 1.0000

Qty

Date

Status

Wearshoe

Warehouse	Loc Qty	Loc Code	
Location			
OFFSHORE			
FG	2		
34806 •	2		
Main Warehouse			
FP19	40		
51925	1		- the 22
54772 ✓	13		1 DK 10-03-3.
55024	12		
55333	14		4
Main Warehouse			
ST	2		

Dart	Aero	spac	e Ltd
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W/O:			WC	RK ORDER CHANG	GES				-
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
		solution:							
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DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
	1					1			<u> </u>

Picklist Print

Page 10

February 10, 2010 2:56:19 PM

Work Order ID: 56135

D205-634-041 Parent Item:

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Qty

Component Item ID/

Replacement Mfg/

Manufactured

Bin Primary No

Last

52562

Unit of Each

141

668.0000 16.0000

Qty on Remaining

Date

Status

D2594-3

O-Ring, 205 Skidtube

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	527	
51613 \	27	
55546	500	
Main Warehouse		
ST ,	141	

Route

200

16 pl/2-03-3.

W/O:			W	ORK ORDER CHANG	SES		***************************************		
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February 10, 2010 2:56:19 PM

Work Order ID: 56135

Parent Item:

D205-634-041

Parent Item Name:

Component Item ID/

D2594-1

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ **Comments:** IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Replacement Mfg/

Manufactured

Bin Primary

Last

Route 200

Unit of Each

Qty on 705.0000 16.0000

Remaining

Start Date: 2/10/10

Start Qty: 1.00

Qty

Date

Required Date: 2/26/10

Required Qty: 1.00

Status

Plug, 205 Skidtube

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	577	
54008	1	
54643	15	
55002	561	
Main Warehouse		
ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

16 B 1003-3.

W/O:			W	ORK ORDER CHANG	ES			
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA :	Date:	
		solution:						
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	JIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		
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DESI	GN e./	DRAWN BY	DADT ACROODAGE LED
	H	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED.	APPROVED	DRAWING NO. REV. D
		#	D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.	02.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND

GASKETS, INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description
Х		D2580-041	SKIDTUBE ASSEMBLY
	Х	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130	INSERT
		or AKS7-1032-130	
]	or AKS4-1032-130	
		or AELS-1032-130	<u> </u>
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMART
WITHOUT NOTICE
WORK ORDER
NO. 5 (2) (2) (2)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

SEE NOTES ON

PAGE 2 FOR D2580-041 AND

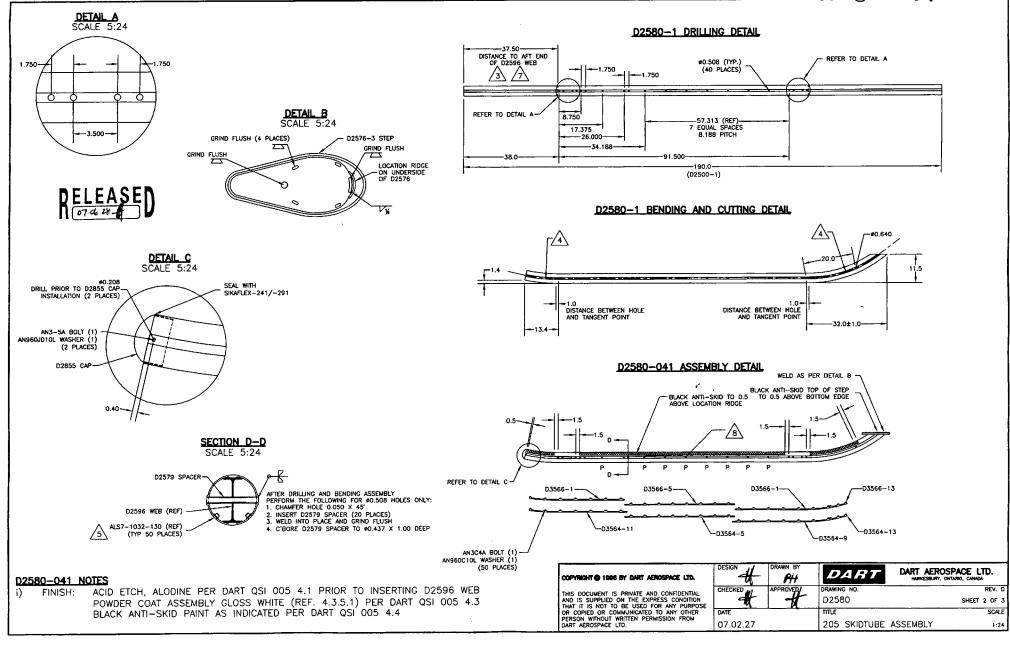
PAGE 3 FOR D2580-045

8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

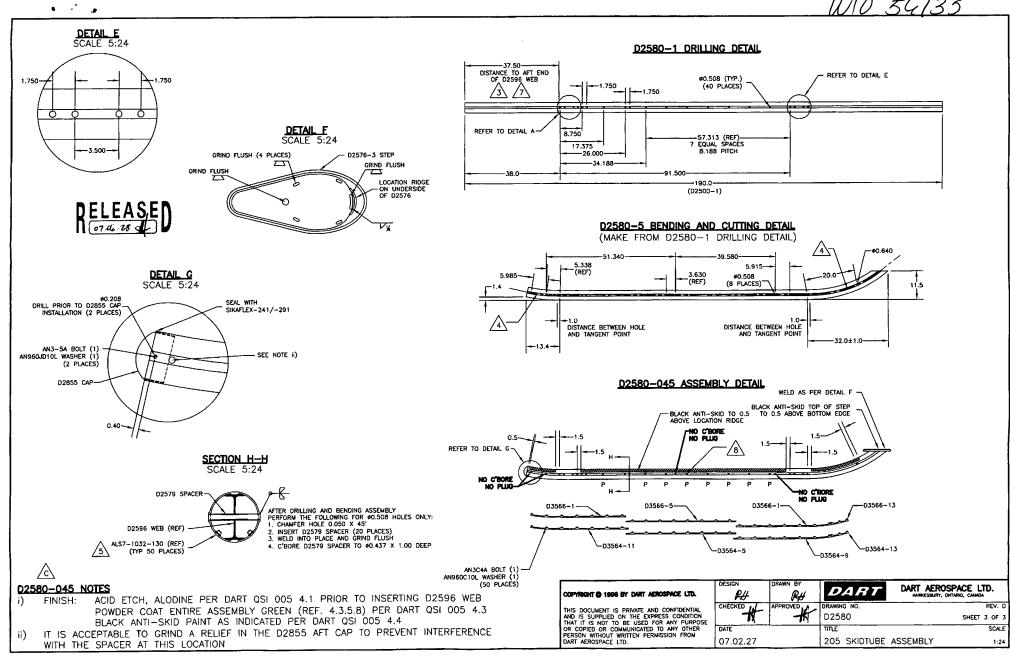
Copyright @ 1996 by DART AEROSPACE LTD

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				Disposition: Q/							
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WO 56135



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NO. AZL

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Bardas Elliett	
Job number: 56184	
Part number: D205 634.041	
Description: 205 skid tube	
Welding Process: Tig[Mig[]	
Welding Process: Tig[Mig[] Base materiel: Always are	
Current: AC[\ DC[]	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks:	pass[] fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[// fail[]
Overlap (cold lap)	pass[fail[]
Porosity (surface):	pass[] fail[]
Coloration:	pass[] fail[]
Qualifier (D)	Date of Test Coupon <u>た. む. 23</u>
Welder Boolay Ellipst	Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld